



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-667-107BL
Job Sheet 168325-A



Part No: D206-667-107BL

Job Qty: 1 ea

Part Name: Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/20/17

Created By: Mario Poulin

Type: SOLD

Description:

Customer: Air Evac Lifetech (CAEVA02)

Air Medical Group Holdings, Concur Invoice Capture C/O ("AEL"), 10700 Prairie Lakes Drive Eden Prairie, MN, 55344 USA ph:(636) 695-5385

Note: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417M-13

Ship Via:

PO 38505

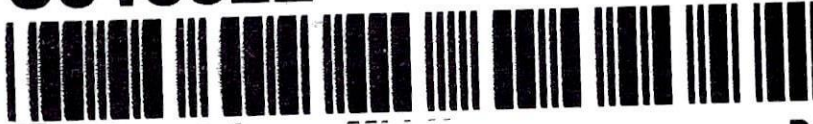
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea		11/17/17	0.00	0.00	Start Up Stores/Pkg-1		<i>TH</i>
110	Packaging	1 pcs		11/17/17	0.00	0.00	Packaging1		<i>TH</i>
120	CNC Bend Crosstubes	1 pcs		11/18/17	0.00	4.32	CNC Bend Crosstube		<i>TH</i>
130	QC	1 pcs		11/18/17	0.00	0.00	QC15		<i>TH</i>
140	Crosstubes	1 pcs		11/18/17	0.00	2.87	Crosstube		<i>TH</i>
150	HandFXtube	1 pcs		11/18/17	0.00	0.74	HandFinish5		<i>TH</i> <i>DAE</i>
160	QC	1 pcs		11/18/17	0.00	0.00	QC7		<i>DAE 38</i>
170	QC	1 pcs		11/18/17	0.00	0.00	QC5		<i>38 9-88</i>
180	Outsource	1 pcs		11/18/17			SKY002-VC		<i>9-88</i> <i>met</i>
190	Packaging	1 pcs		11/18/17	0.00	0.00	Packaging2		<i>met</i> <i>17-11-27</i>
200	QC	1 pcs		11/18/17	0.00	0.00	QC5		<i>38</i>
210	Outsource	1 pcs		11/18/17			ATE003-VC		<i>9-88</i>
215	Packaging	1 pcs		11/18/17	0.00	0.00	Packaging2		<i>DAE</i>
220	QC	1 pcs		11/18/17	0.00	0.00	QC14		<i>38</i>
230	Crosstubes	1 pcs		11/20/17	0.00	2.87	Crosstube	<i>AR</i> FEB 11 2018	<i>38</i>
240	QC	1 pcs		11/20/17	0.00	0.00	QC5		<i>38</i>
250	Packaging	1 pcs		11/20/17	0.00	0.00	Packaging1		<i>38</i>
260	QC	1 pcs		11/20/17	0.00	0.00	QC4		<i>38</i>
265	DC	1 pcs		11/20/17	0.00	0.00	DC		<i>38</i>
270	Packaging	1 pcs		11/20/17	0.00	0.00	Packaging3		<i>38</i>
280	QC21-FG	1 Ea		11/20/17	0.00	0.00	QC21		<i>38</i>

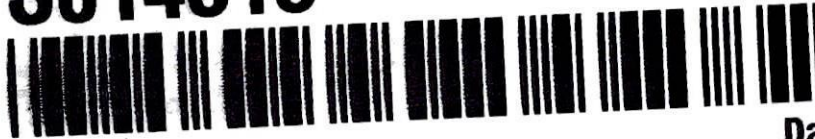
Part Op 120 - Bend tube as per Dwg D206-667-147 using CNC bender program
Descriptions: 140 - ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 1- Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill all (3) top holes. Holes facing inboard. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 2- Drill Fwd rivet holes using drill Jig DT8787 fwd as per Dwg D206-667-147. Note: Fwd side has 3x top holes. Facing inboard. 3- C'sink holes as per Dwg D206-667-147. Allow rivet to sit below surface to compensate for paint. 4- Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins. Drill ONLY 2 top holes ONLY plug most bottom holes to prevent accidental drilling. Drill holes and ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-147. Drill only the top (2) holes. ***** ENSURE PROPER JIG POSITIONING BEFORE DRILLING***** , VERIFIED BY: ***** 5- Drill Aft rivet holes using drill Jig
150 - ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID

DART
AEROSPACE
S013022



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Email: sales@dartaero.com
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S014313



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Fwd Crosstube – Mid Height 206L / L1 / L3 / L4, Blue

PART NO: D206 – 667 – 107BL
Revision:
Operation: Outsource
Change No:

Mfg Date: 11/29/17
Job No: 168325 – A

ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 39646 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

210 - ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____
BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART # TO MATCH
W/O _____ **MASK SCRIBE B# & P# AND VERIFY** 1-Prime inside and outside crosstube as per

QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Finish Time: _____
PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

220 - Wrap in plastic bag to protect from scratches **VERIFY BY _____ BATCH # TO MATCH W/O

230 - 1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n'
wipe 2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: 138708 3- Torque
bolts as per dwg exp 5/18 Install nut plates as per Dwg D206-667-147. Touch-up rivet heads with Imron paint.

240 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART #
TO MATCH W/O _____

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ **VERIFY BY _____ PART #
TO MATCH W/O _____

265 - Photocopy bluefile and create labels as per PPP D206-667-107 chg 003

270 - Identify and pack for shipping as per PPP D206-667-107 Location: FG035

-230 Cure time Start 18-02-20 Finish 18-02-24

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D206-667-147TRN	1	6	0	0
230-Crosstubes	D206-667-017 <u>5049001</u>	①	13	0	0
	D2873-043 <u>5003319</u>	② <u>5034892</u>	113	0	0
	D2873-045 <u>5003319</u>	② <u>5034892</u>	37 <u>5018918</u>	0	0
	D2891-1 <u>5003319</u>	② <u>5034892</u>	32	0	0
	D3595-063-395 <u>5003319</u>	④ <u>5034892</u>	67	0	0
	MS20601-AD4W8 <u>5003319</u>	④ <u>5034892</u>	387	0	0
	MS21920-20 <u>5003319</u>	④ <u>5034892</u>	106	0	0
250-Packaging	AN5-30A	4	42	0	0
	AN5-32A	4	141	0	0
	AN5-7A	10	2,682	0	0
	AN970-4	12	83	0	0
	MS21042L5	4	413	0	0
	NAS1149D0563J	18	1,347	0	0

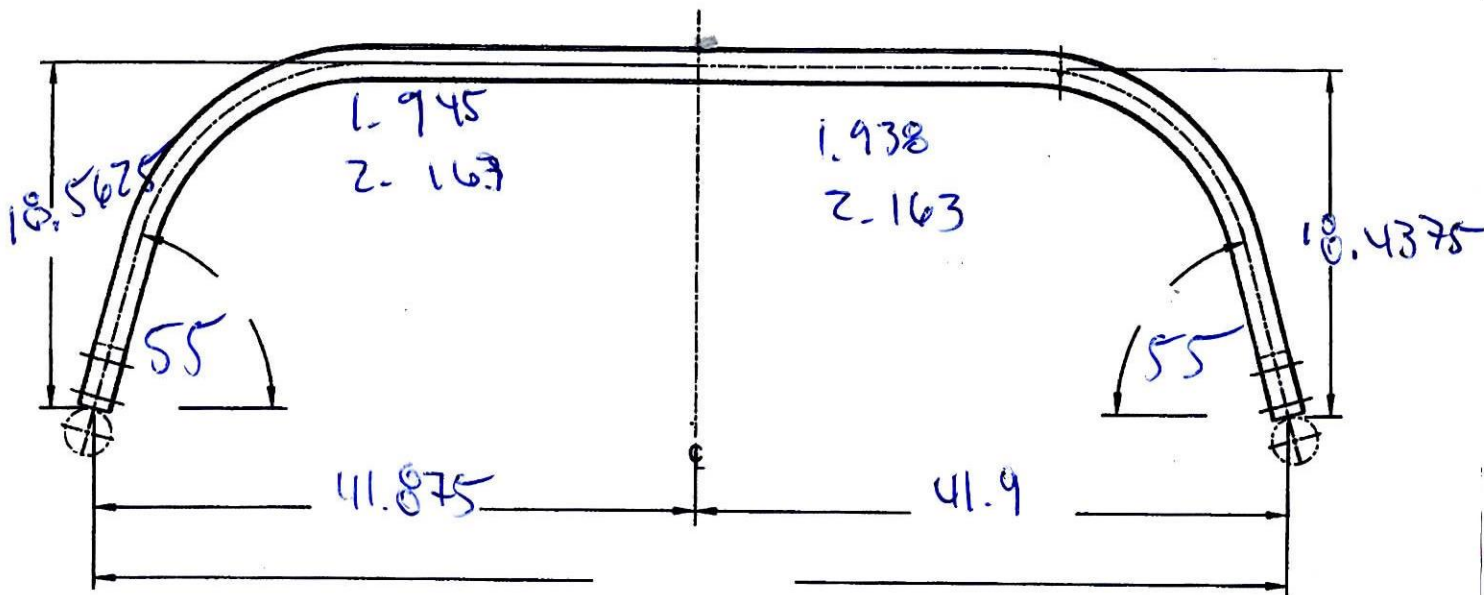
Part Specifications

Specifications could not be found.

Plex 11/13/17 1:21 PM dart.poulin.mario

DART AEROSPACE LTD		Work Order:	168325-A 168279-D
Description: Crosstube Mid Fwd (206L)		Part Number:	D206-667-107
Inspection Dwg: D206-667-147 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	18.34	18.60
1/2 Span	41.79	42.05
Angle	54°	56°
Total Span	83.59	84.09
Bending Passes	10	--
Crushing	--	6%



	Side A	Side B
Bending Passes	18	18
Crushing	5.3%	5.5%
Comments		

QC15 Inspection	<i>[Signature]</i>
Date	17-01-22

Rev	Date	Change	Revised by	Approved
A	12.02.15	New Issue	KJ	
B	12.04.16	Added bending, crushing dimensions	KJ <i>[Signature]</i>	<i>[Signature]</i>



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34167	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038475
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 8 CROSSTUBES AS PER PO038475

4 AFT CROSSTUBES, P/N# D206-667-207BL , J/S# 168327-C, 168327-D, 168327-E, 168327-F

4 FWD CROSSTUBES, P/N# D206-667-107BL , J/S# 166712, 166581, 168325-A, 168325-B

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						NOV 24 2017	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	Name: RAFIK MELIKIAN	ACA/SCA Stamp 	Date: NOV 24 2017



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038475

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038475
PO Date: 11/24/17
Due Date: 11/24/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166712	D206-667-107BL	-	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	11/24/17	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
2	166581	D206-667-107BL	-	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	11/24/17	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
3	168325-A	D206-667-107BL	-	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI		Firmed	11/24/17	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88

K 20 171-27

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34167	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO038475
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

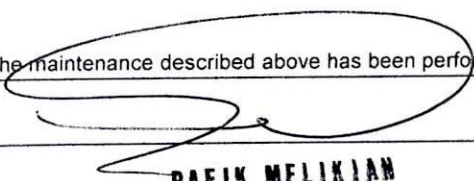
CARRY OUT NDT ON 8 CROSSTUBES AS PER PO038475

4 AFT CROSSTUBES, P/N# D206-667-207BL , J/S# 168327-C, 168327-D, 168327-E, 168327-F

4 FWD CROSSTUBES, P/N# D206-667-107BL , J/S# 166712, 166581, 168325-A, 168325-B

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13						NOV 24 2017	 
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:		ACA/SCA Stamp 	Date: NOV 24 2017
Name:			

RAFIK MELIKIAN



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038475

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
				038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order								
4	168325-B	D206-667-107BL	-	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	11/24/17	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
5	168327-C	D206-667-207BL	-	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	11/24/17	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
6	168327-D	D206-667-207BL	-	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue Outsource process - NDT per QSI038 4.1 *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	11/24/17	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
7	168327-E	D206-667-207BL	-	Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue		Firmed	11/24/17	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER PO038505

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
				outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____								
3	168325-A	D206-667-107BL		Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O ***VERIFY BY _____ PART # TO MATCH W/O ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____		Firmed	11/29/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
4	168325-B	D206-667-107BL	-	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O ***VERIFY BY _____ PART # TO MATCH W/O ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____		Firmed	11/29/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



Dart Aerospace Ltd.
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PURCHASE ORDER

PO039146

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO039146
PO Date: 2/28/18
Due Date: 3/2/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D206-667-107BL			Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue	Firmed	3/2/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Line Item Note job #168325-A - REWORK											
2	D206-667-207BL			Aft Crosstube - Mid Height 206L / L1 / L3 / L4, Blue	Firmed	3/2/18	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Line Item Note JOB# 168327-F REWORK											
Grand Total:										\$450.00	

Order Notes

Plex 2/28/18 3:16 PM dart.baker.diane

Handwritten initials: "CL" and "PAB"



Dart Aerospace Ltd.
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K6A 1K7
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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001868	S053759	AN5-30A	Bolt	S019375 ✓	ST337	4
001868	S053758	AN5-32A	Bolt	s015692 ✓	ST336	4
001868	S053757	AN5-7A	Bolt	fm123355 ✓	OVER009	10
001868	S053756	AN970-4	Washer	s016395 ✓	ST321	12
001868	S053754	MS21042L5	Nut	s016880 ✓	ST303	4
001868	S053753	NAS1149D0563J	Washer	s025743 ✓	ST263	18

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 3/22/18 9:11 AM dart.quirion.sonia